

Work Order ID 71016

Tuesday, June 21, 2011 8:50:38 AM



Page 1

Item ID: D3266-041

Accept



Setup Start



Revision ID:

Item Name: Basket Lid Assembly

Stop



Start Date: 6/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-06-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3266

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut (4) D2236 From D3166-3 2-Cut 3/4" x 3/4" square tubing as per Dwg D3266 3-Drill holes in D3266-1 as per Dwg D3266 using Drill Jig DT8305

4-Debur & Remove all markings from material 5-Weld as per Dwg D3266 using Welding Table and corner jig Do

11.09.12

SS. Rod B# DT9436 M114649

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11.09.16

PMB/12 11/09/16
P10

| W/O: 71016 | | WORK ORDER CHANGES | | | | | |
|------------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3266-41 PAR #: _____ Fault Category: Large Fab/Welding NCR: Yes No DQA: CK Date: 11/09/21
11-851 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 11/09/21

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|-----------------------------|--|--------------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 11/09/13 | #100 | when drilling & welding D3266-1 welder drilled the hole and welded D2327-1 on the wrong side | W 11/09/13 | -Scrap + Destroy qty x2 D3266-1 + D2327-1 Replace D2327-1 B# 69728 | 11/09/13 PMB/EL | 11/09/13 | W 11/09/13 | S 11/09/13 |
| | | R.C. LCA new employee still in training (Drawing is clear + training was completed correctly) | W 11/09/13 | M340.75 W0065 M# 118773 as per Dwg. SS Rev B# 1114649 | 11/09/13 PMB/EL | 11/09/13 | W 11/09/13 | S 11/09/13 |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 71016

Tuesday, June 21, 2011 8:50:38 AM



Page 2

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Setup Start



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Start Date: 6/21/2011 Start Qty: 1.00



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Required Date: 6/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

8 w/02/19

Memo

0.00

0

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

1ST COAT: ☐ START TIME: 4:00 ☐ FINISH TIME: 4:30 ☐ OVEN

TEMPERATURE: 400°F

2ND COAT: ☐ START TIME: 4:30 ☐ FINISH TIME: 5:00 ☐ OVEN

TEMPERATURE: 400°F

0.00

2nd Coat

1X M-L 11/02/19

140



HandFinish

Hand Finishing

HandFinishing

Memo

Wing Walk Batch: 118313 ☐ and Spray Paint black

Batch: 118119 ☐ as per Dwg D3266 and QSI 005 4.4

0.00

1X M-L 11/02/19

1 BR 11-9-20.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 71016

Tuesday, June 21, 2011 8:50:38 AM



Page 3

Item ID: D3266-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 6/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|----------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | 1 | 0 | 11/09/20 | |
| 160 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | 11/9/20 | |

ME
11-09-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 8:50:44 AM

Page 1

Work Order ID: 71016

Parent Item: D3266-041

Parent Item Name: Basket Lid Assembly

Start Date: 6/21/2011

Required Date: 6/27/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP Rev:B Re-Format 05-11-03 JLM
IPP Rev:C 08-09-10 revB as per dwg (ecn 08-524) DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|--|--|--------------|----|--|--|-----|------|---------|---|---|--|--------------|--|
| D2232-1  Basket Hinge | | Manufactured | No | | | 100 | Each | 20.0000 | 2 | 2 | | PMB 11/09/12 | |
|--|--|--------------|----|--|--|-----|------|---------|---|---|--|--------------|--|

Location Loc Qty Loc Code

WA 20
70842 20

| | | | | | | | | | | | | | |
|--|--|--------------|----|--|--|-----|------|---------|---|---|--|--------------|--|
| D2327-1  Spacer Bushing | | Manufactured | No | | | 100 | Each | 33.0000 | 2 | 2 | | PMB 11/09/16 | |
|--|--|--------------|----|--|--|-----|------|---------|---|---|--|--------------|--|

Location Loc Qty Loc Code

WA 20
69728 20
WA005 13
64899 13

| | | | | | | | | | | | | | |
|---|--|--------------|----|--|--|-----|------|--------|---|---|--|--------------|--|
| D2506  Label Plate | | Manufactured | No | | | 100 | Each | 6.0000 | 1 | 1 | | PMB 11/09/16 | |
|---|--|--------------|----|--|--|-----|------|--------|---|---|--|--------------|--|

Location Loc Qty Loc Code

WA 6
B 71087 6
69262 6

2727 SRARP (CPL)

*

PTO

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 8:50:44 AM

Page 2

Work Order ID: 71016

Parent Item: D3266-041

Parent Item Name: Basket Lid Assembly

Start Date: 6/21/2011

Required Date: 6/27/2011

Start Qty: 1.00

Required Qty: 1.00

D2581

 Mounting Bracket

Manufactured No

100 Each

70.0000 2 2



PAB 11/09/16

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA | 70 | |
| 68964 | 6 | |
| 69258 | 28 | 2 |
| 69739 | 36 | |

D3166-3

 Basket Hoop

Manufactured No

100 Each

2.0201 1 1



PAB 11/09/16

| Location | Loc Qty | Loc Code |
|----------|------------|----------|
| WA007 | 2.02010527 | 1 |
| 64928 | 0.02010527 | |
| 68442 | 2 | |

M304EX0.75-16F

 Expanded Metal Flat SS

Purchased No

100 sf

572.1484 10 10



PAB 11/09/16

| Location | Loc Qty | Loc Code |
|----------|----------|----------|
| MAT | 38.2107 | |
| 117708 | 38.2107 | |
| WA | 533.9377 | |
| 115012 | 95 | 10 |
| 117197 | 102.9036 | |
| 117455 | 16.0341 | |
| 117896 | 320 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 8:50:45 AM

Page 3

Work Order ID: 71016

Parent Item: D3266-041

Parent Item Name: Basket Lid Assembly



Start Date: 6/21/2011

Required Date: 6/27/2011

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

565.5786

27

28.42105



304 SQ Tube .75x.75x.065W



PM 11/09/10

S

Location

Loc Qty

Loc Code

MAT018

451.7236

117598

374.0249

117636

77.6987

WA007

113.8549906

116267

99.549272

116763

14.3057186

118 773

28.42105

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

| QTY -041 | PART NUMBER | DESCRIPTION |
|-------------|-------------|------------------|
| X | D3266-041 | BASKET ASSEMBLY |
| 2 | D2232-1 | HINGE PLATE |
| 4 | D2236 | RIB |
| 2 | D2327-1 | BUSHING |
| 1 | D2506 | LABEL PLATE |
| 2 | D2581 | MOUNTING BRACKET |
| 2 | D3266-1 | RIB |
| 2 | D3266-3 | RIB |
| 6 | D3266-5 | RIB |
| 3 | D3266-7 | RIB |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71814

PL11-06-21

RELEASED
08-09-04/14



NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

| B | INCORPORATED A1. DRAWING UPDATED TO CURRENT STANDARDS. SHEET 5 ADDED. RIB MATERIAL WAS 0.060 THICK. | AJS | 08.08.15 |
|------------|---|-----|----------|
| A | NEW ISSUE | CP | 04.02.02 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DS | | |
| DRAWN | AJS | | |
| CHECKED | <i>[Signature]</i> | | |
| MFG. APPR. | <i>[Signature]</i> | | |
| APPROVED | <i>[Signature]</i> | | |
| DE APPR. | <i>[Signature]</i> | | |
| DATE | 08.08.15 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D3266 SHEET 1 OF 5
TITLE SCALE
BASKET LID ASSEMBLY (350) NTS

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

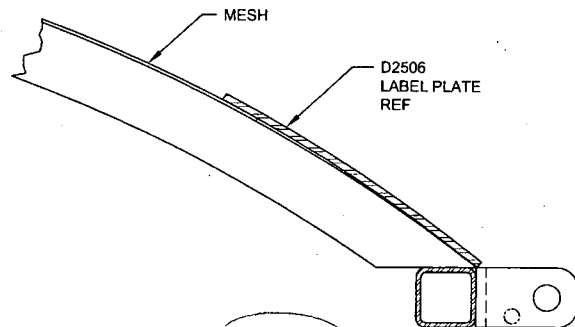
8 7 6 5 4 3 2 1

D

C

B

A



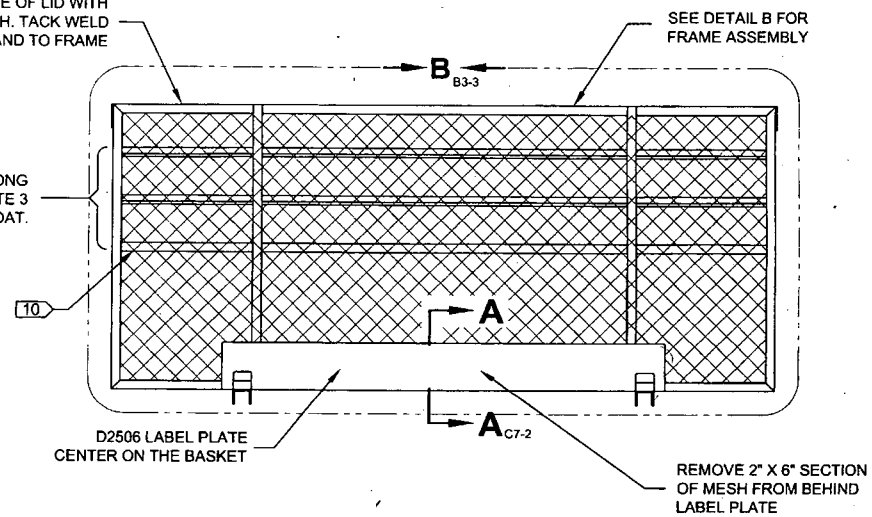
SECTION A-A
(ROTATED 90° CCW)
SCALE NONE

u/b 71016

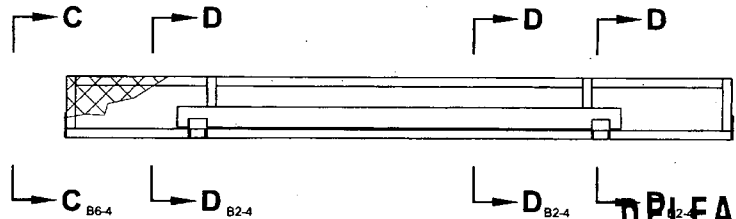


SKIN OUTSIDE SURFACE OF LID WITH
SS MESH. TACK WELD
EACH END STRAND TO FRAME

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.



D3266-041 BASKET LID ASSEMBLY



RELEASED
08-09-2015

ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: FOR OVERALL FINISH SEE SHEET 1
- 3) FINISH: SPRAY PAINT BLACK INSIDE SURFACE AFTER POWDER COAT
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE
PER DART QSI 005 4.4 AFTER POWDER COAT
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004
- 10) TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION

| | | | |
|------------|----------|--|--------------|
| DESIGN | DS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3266 | SHEET 2 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BASKET LID ASSEMBLY (350) | NTS |
| DATE | 08.08.15 | <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

8 7 6 5 4 3 2 1

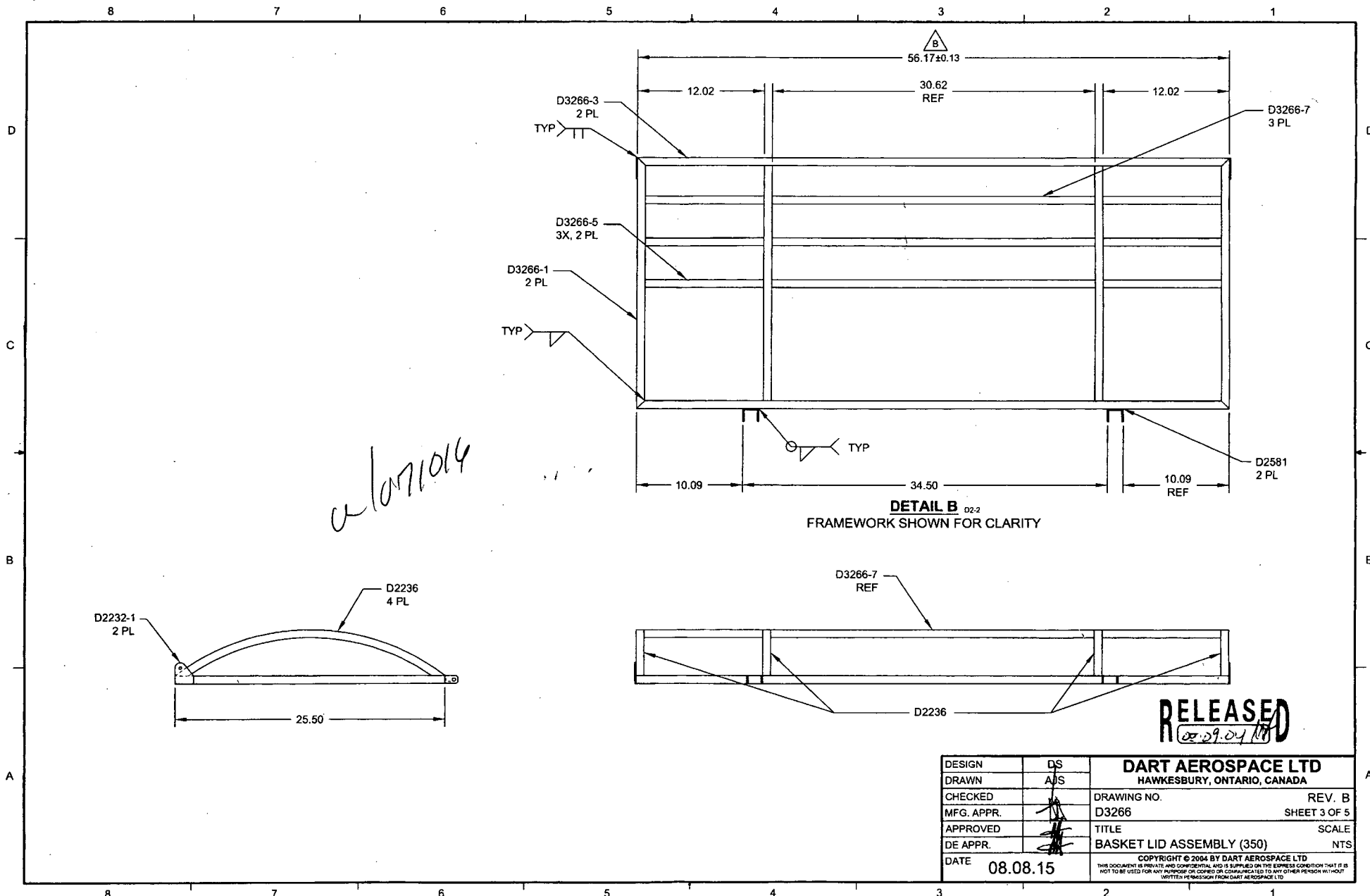
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NOTE: Date & initial all entries



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|------------|----------|---|--------------|
| DESIGN | DS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3266 | SHEET 3 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BASKET LID ASSEMBLY (350) | NTS |
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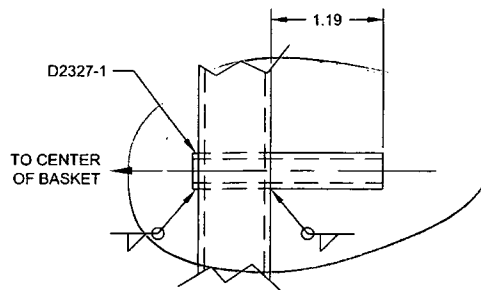
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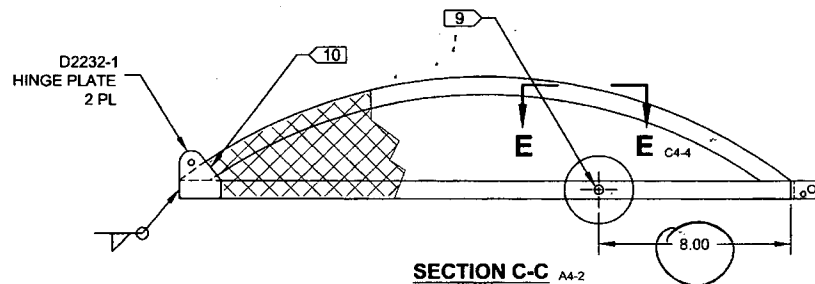
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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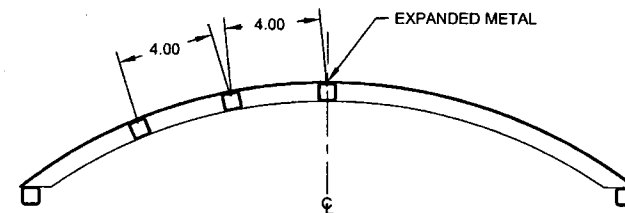
NOTE: Date & initial all entries



VIEW E-E B4-4
SCALE 4X
(BOTH ENDS)



SECTION C-C A4-2
(BOTH ENDS)







SECTION D-D A1-2
A2-2
A3-2
3 PL

NOTES:

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DRILL 3/8 HOLE AND INSTALL D2327-1 USING CLOSEST SPACE IN EXPANDED METAL FOR HOLE LOCATION BOTH ENDS
- 10) TRIM MESH AS REQUIRED TO ALLOW D2232-1 HINGE PLATE TO SIT FLUSH ON FRAME

u/o 7/10/04

RELEASED
08 09 01 10

| | | | |
|--|---|--|--------------|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. B |
| MFG. APPR. |  | D3266 | SHEET 4 OF 5 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | BASKET LID ASSEMBLY (350) | NTS |
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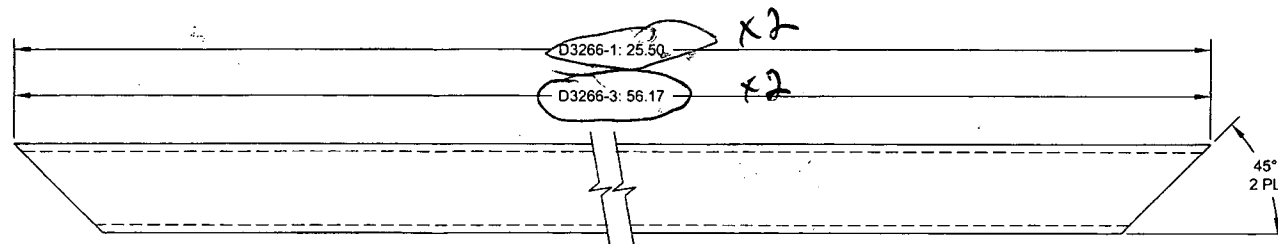
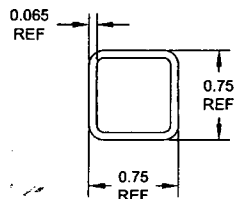
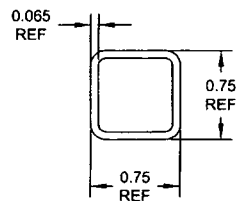
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D3266-1 RIB

D3266-3 RIB

D3266-5 RIB

D3266-7 RIB

W/ 91016

RELEASED
02-09-01/17

RIB NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

| | | | |
|------------|----------|--|--------------|
| DESIGN | JB | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PA | DRAWING NO. | REV. B |
| MFG. APPR. | JS | D3266 | SHEET 5 OF 5 |
| APPROVED | JS | TITLE | SCALE |
| DE APPR. | JS | BASKET LID ASSEMBLY (350) | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries